

Date: Friday, 9/14/2007 2:01:31 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG WELDMENT
Job Number : 34680	
Estimate Number : 12395	
P.O. Number : <i>N/A</i>	Part Number : D33535
This Issue : 9/14/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3353 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31587	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/30/2007 Qty: <i>14</i> Um: Each
Checked & Approved By : <i>[Signature]</i> 07-09-17	
Comment : est rev. A 06.04.24 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B0375X03500	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty.: 0.3360 f(s)/Unit Total : 2.0160 f(s)

1010-1025 BAR .375" thick x 3.50" batch: *M102179*

*HB 07-09-19*

*(14)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3353

Dwg Rev: *A*

Prog Rev: *A*

*HB 07-09-19*

2-Deburr

*(14)*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Bore hole as per dwg D3353

2-Deburr

*[Signature] 07-10-04 (14)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature] 07-10-04 (14)*

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*[Signature] 07-10-04 (14)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 09/10/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 9/14/2007 2:01:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 34680

Part Number: D33535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*2/20/10/05 (14)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(14)*

Comment: FINAL INSPECTION/W/O RELEASE

*2/20/10/09*

Job Completion



*C207110109*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

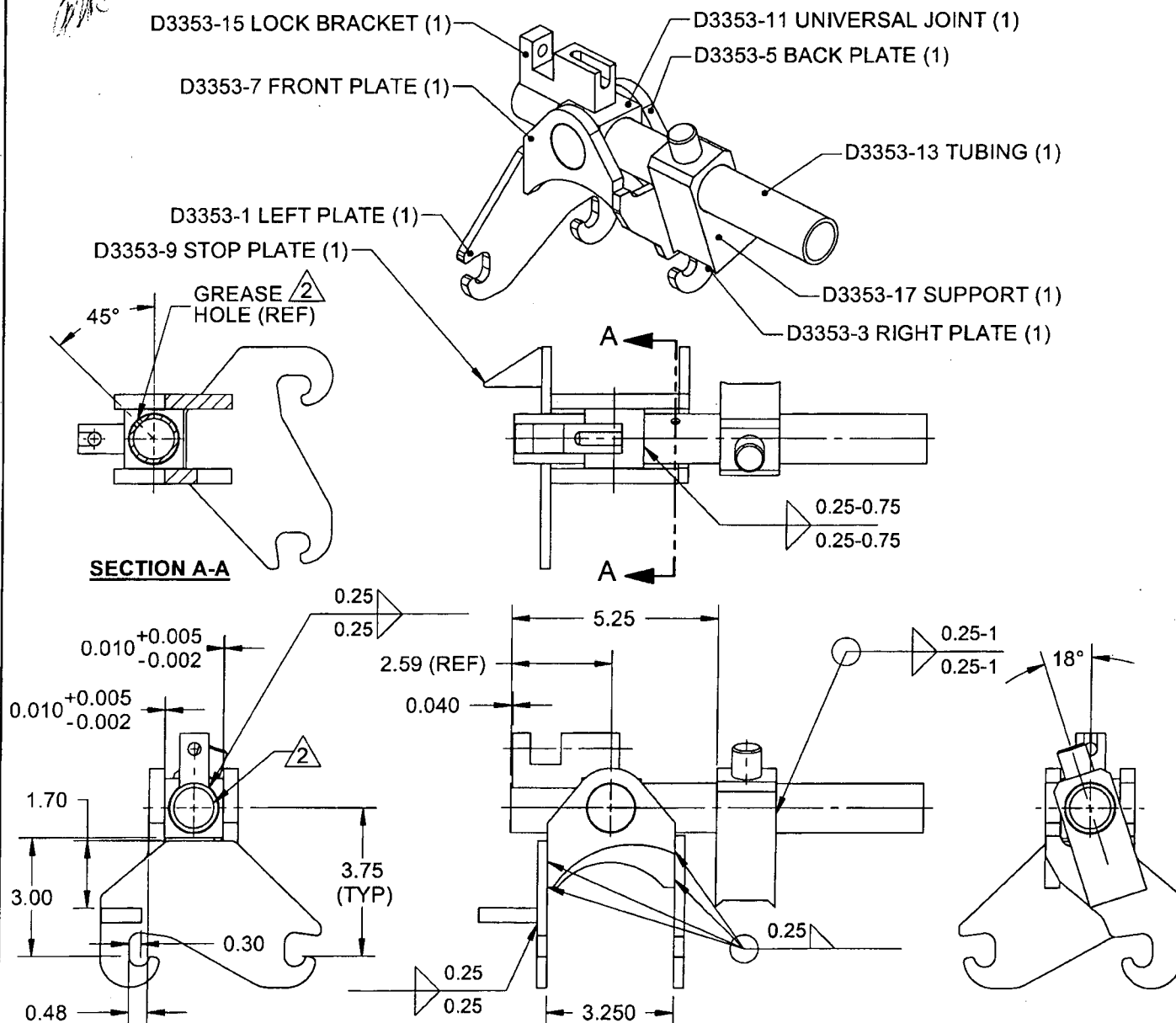
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE <b>04.12.14</b>		TITLE <b>LUG WELDMENT</b>	SCALE 1:4
A	04.12.14	NEW ISSUE	

**RELEASED**  
05/09**D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

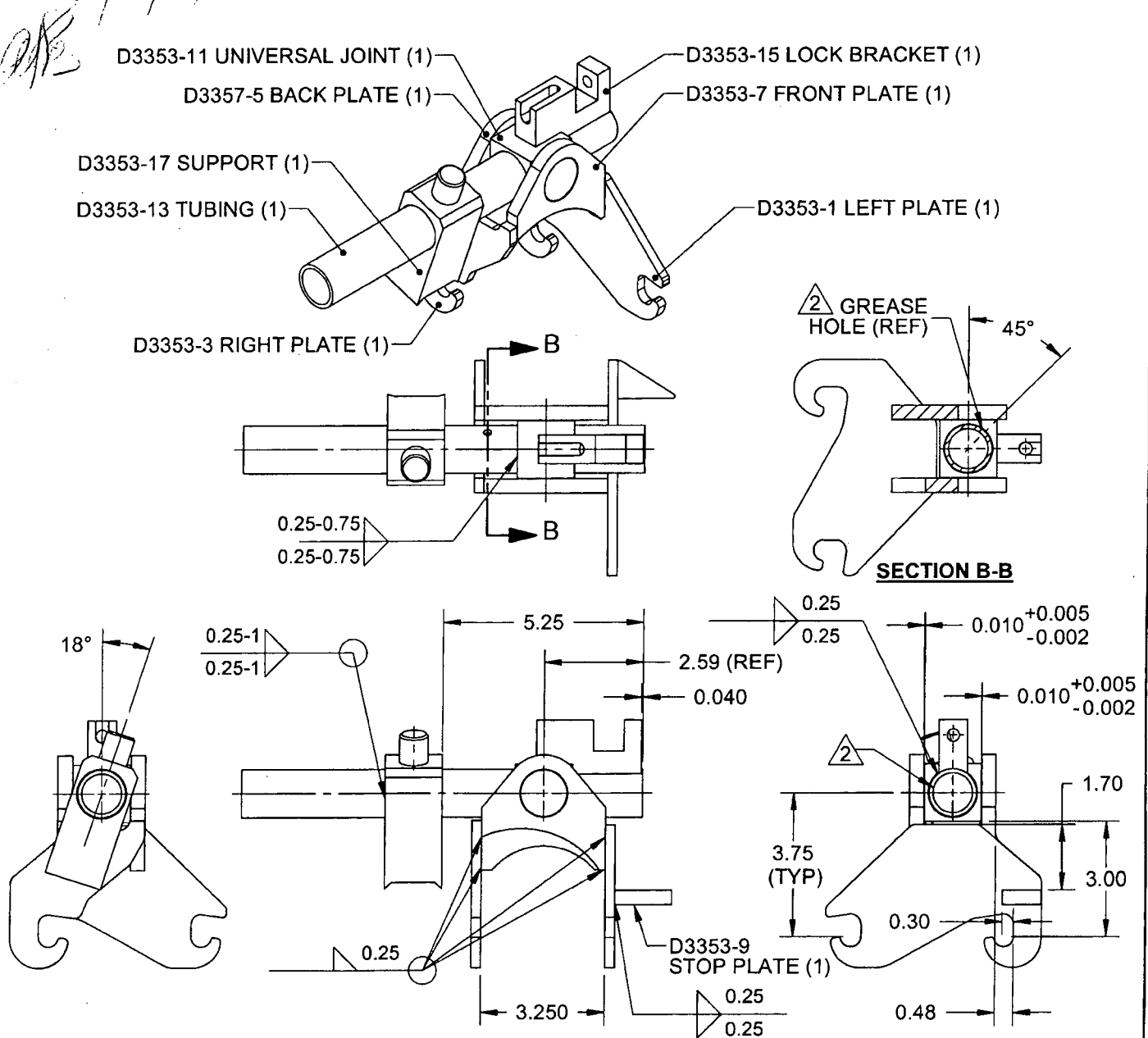
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DATE <b>04.12.14</b>		TITLE <b>LUG WELDMENT</b>	SCALE 1:4



**D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

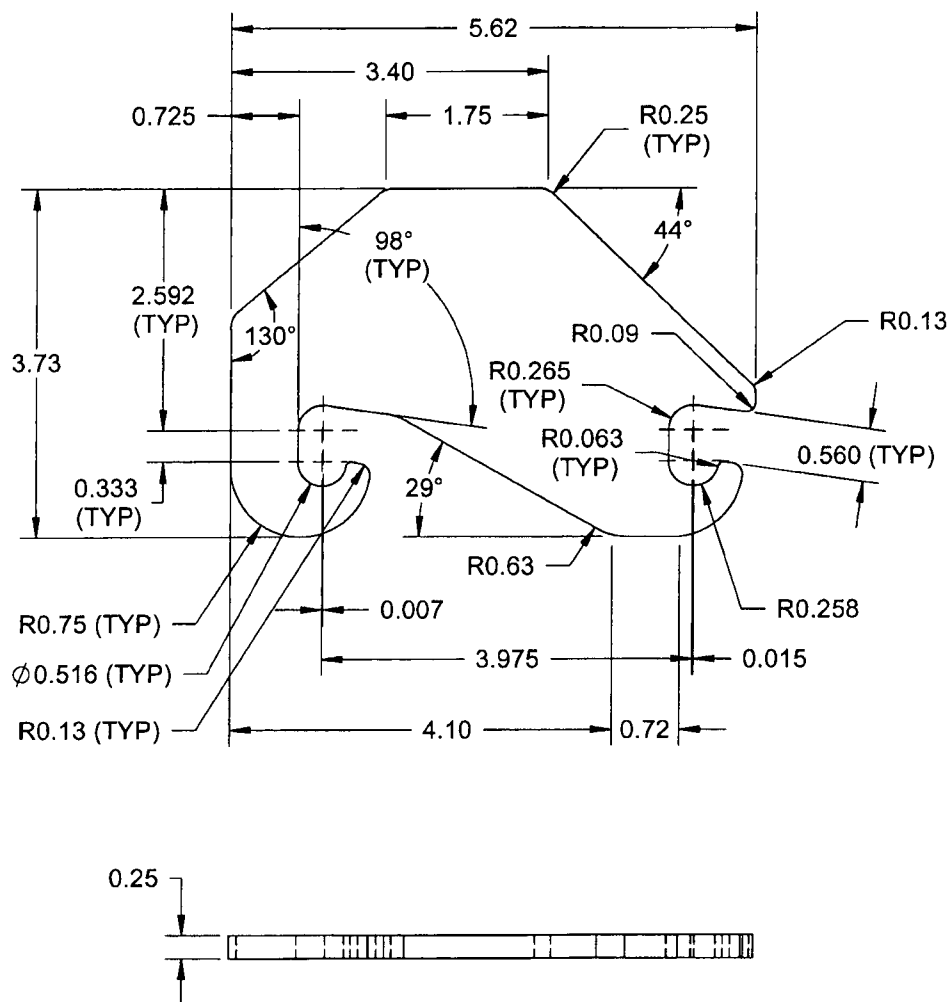
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RELEASED  
01/07/04



### **D3353-1 LEFT PLATE**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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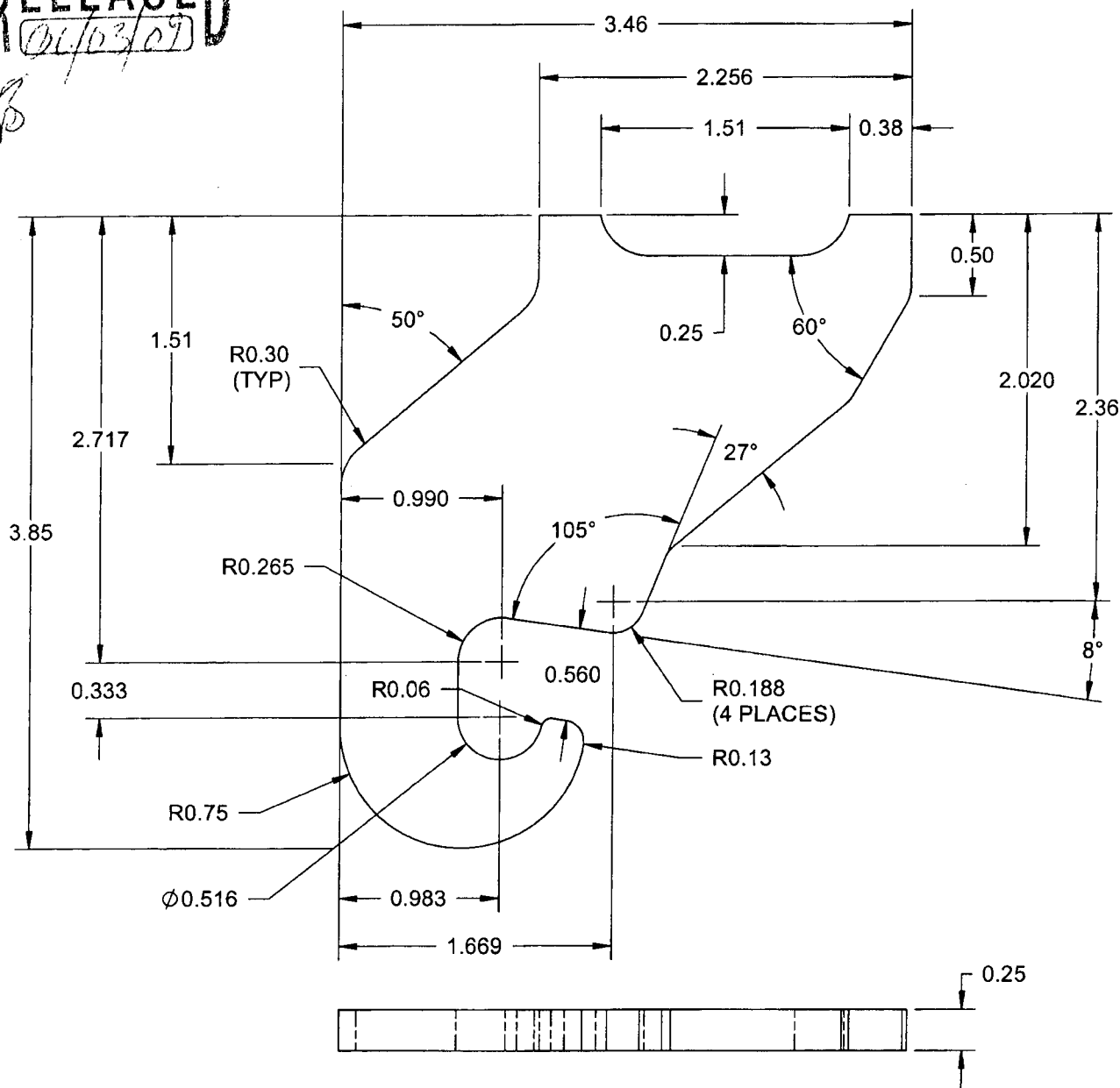
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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01/03/09



### D3353-3 RIGHT PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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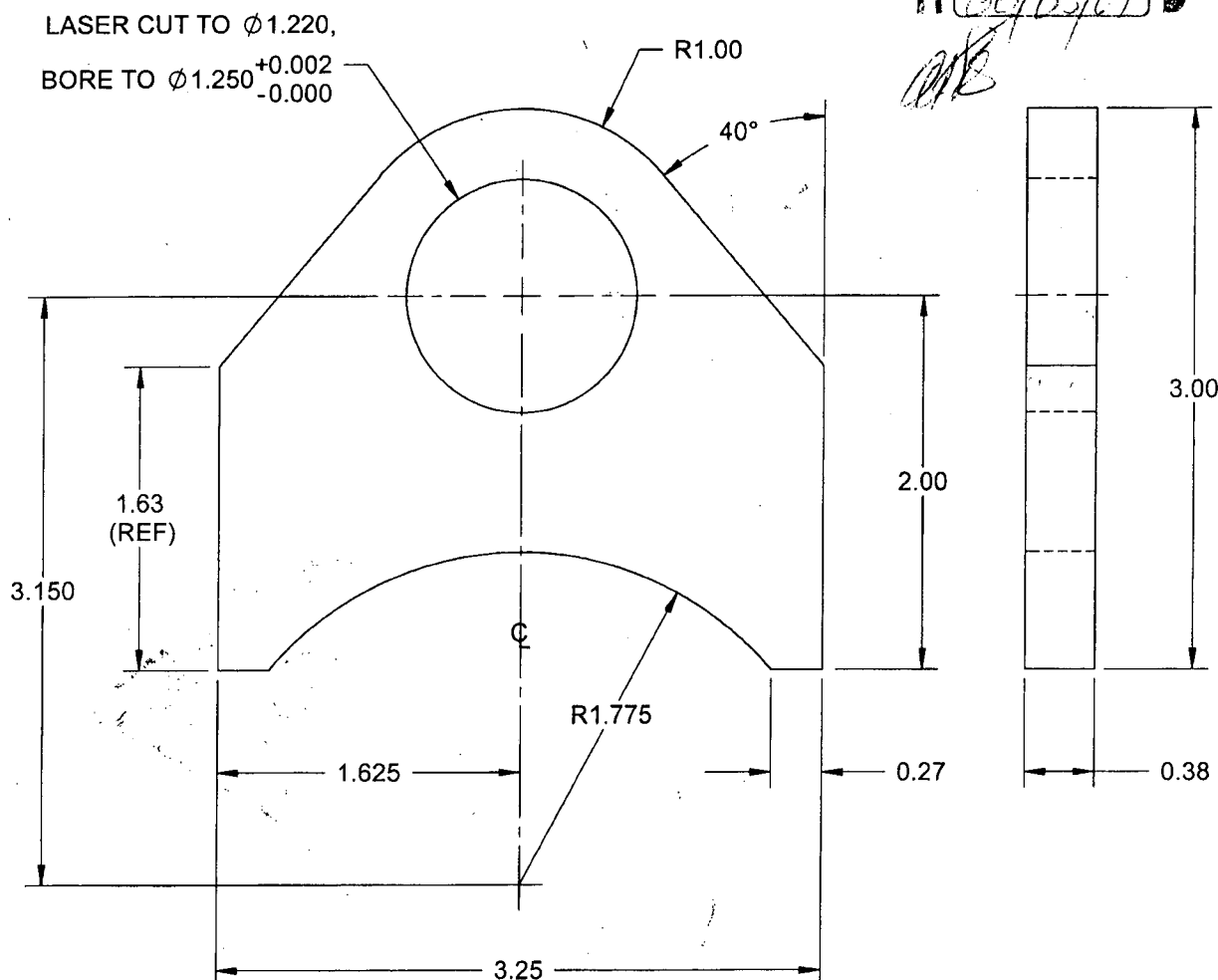
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06/03/09



### D3353-5 BACK PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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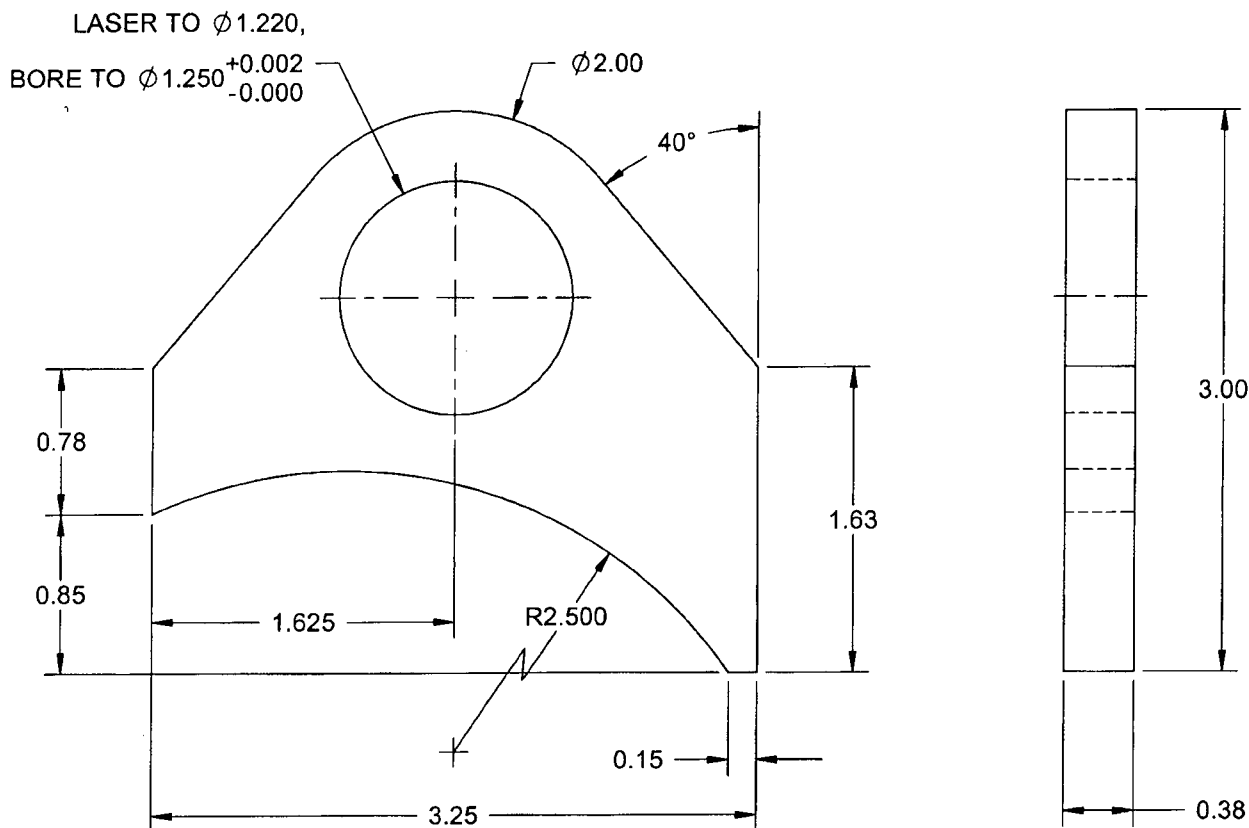
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06/03/07



### D3353-7 FRONT PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES  
STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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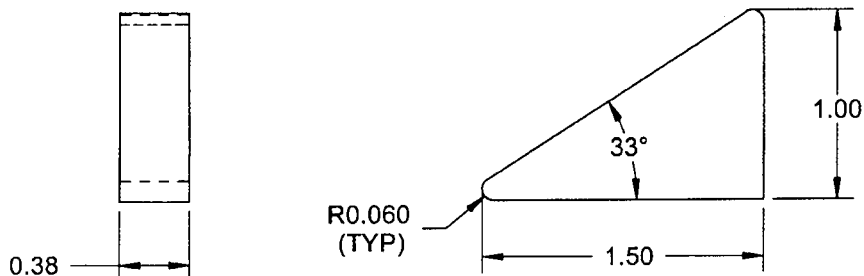
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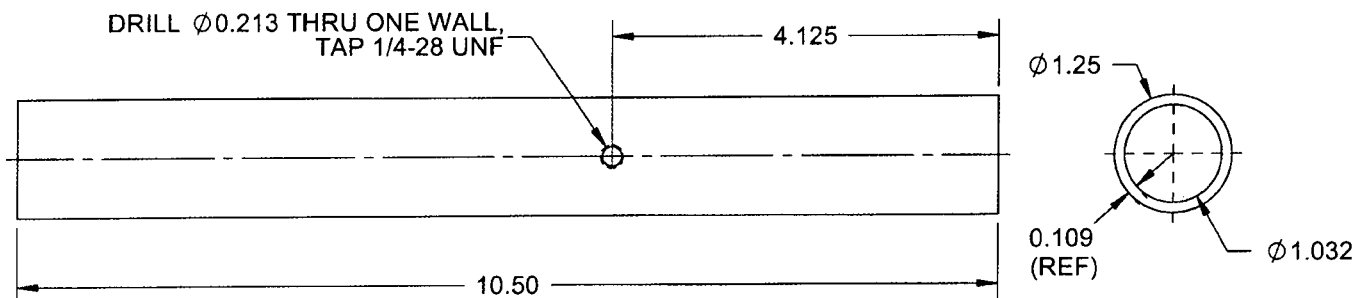
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6/3/09

*[Handwritten signature]*



### D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK  
MILD STEEL BAR (REF. DART SPEC. M1010-B)



### D3353-13 TUBING

#### NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,  
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING  
(REF. DART SPEC. M1020TR1.250W.109)

#### NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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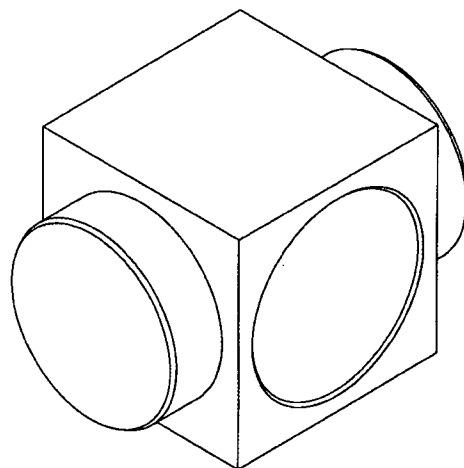
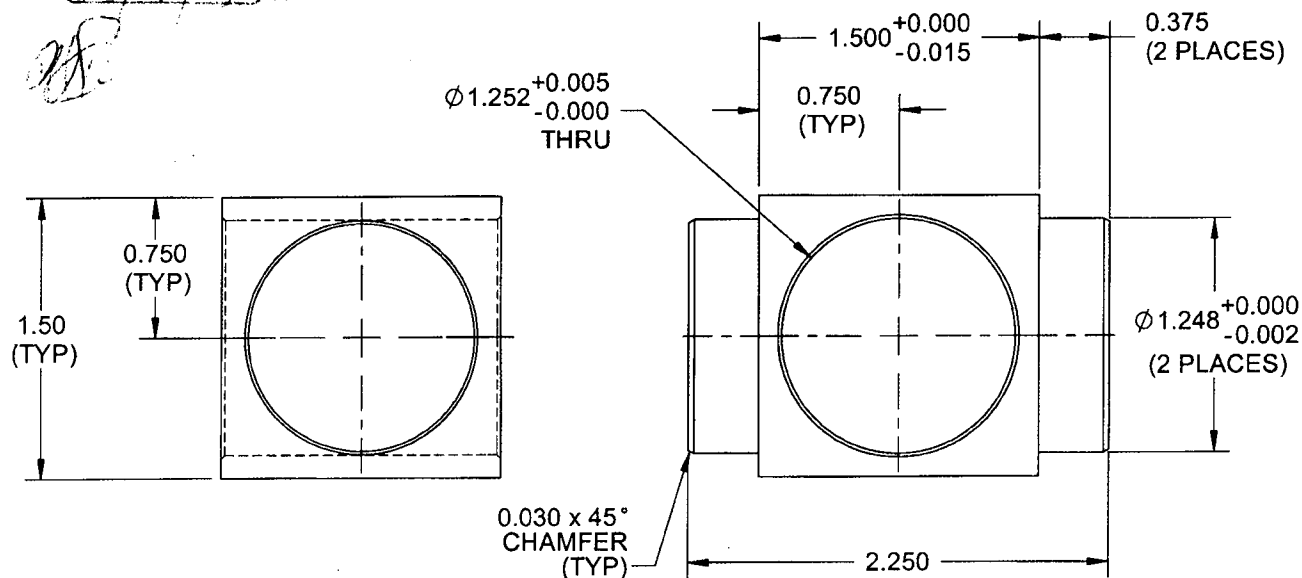
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### D3353-11 UNIVERSAL JOINT

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

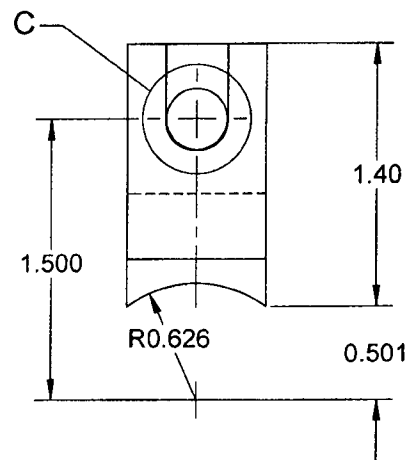
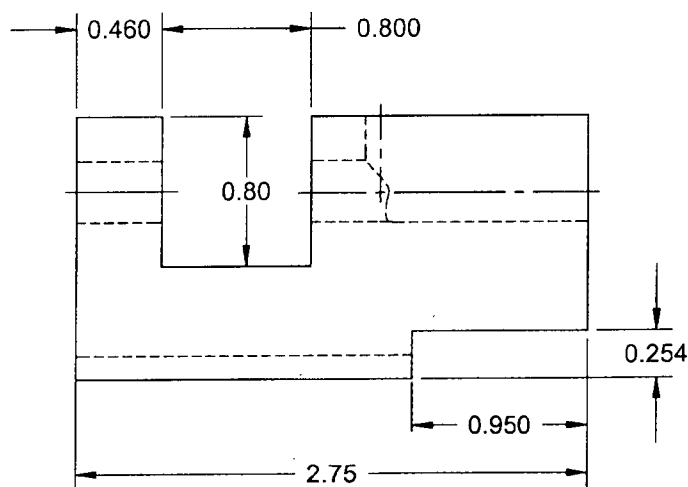
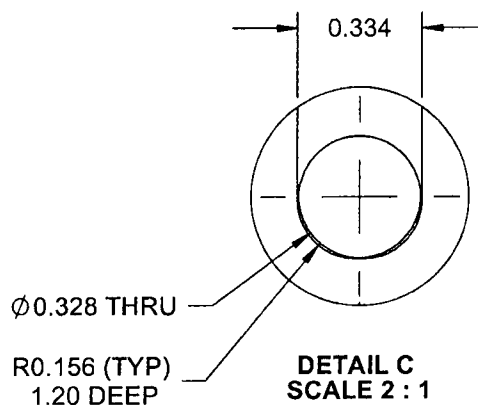
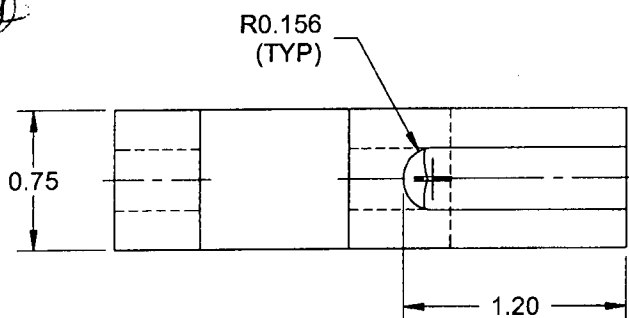
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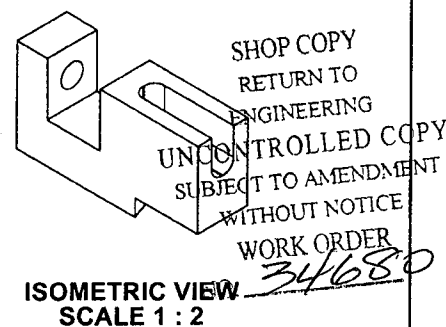
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DATE <b>04.12.14</b>		TITLE <b>LUG WELDMENT</b>	SCALE 1:1

**RELEASED**  
06/22/09**D3353-15 LOCK BRACKET****NOTES:**

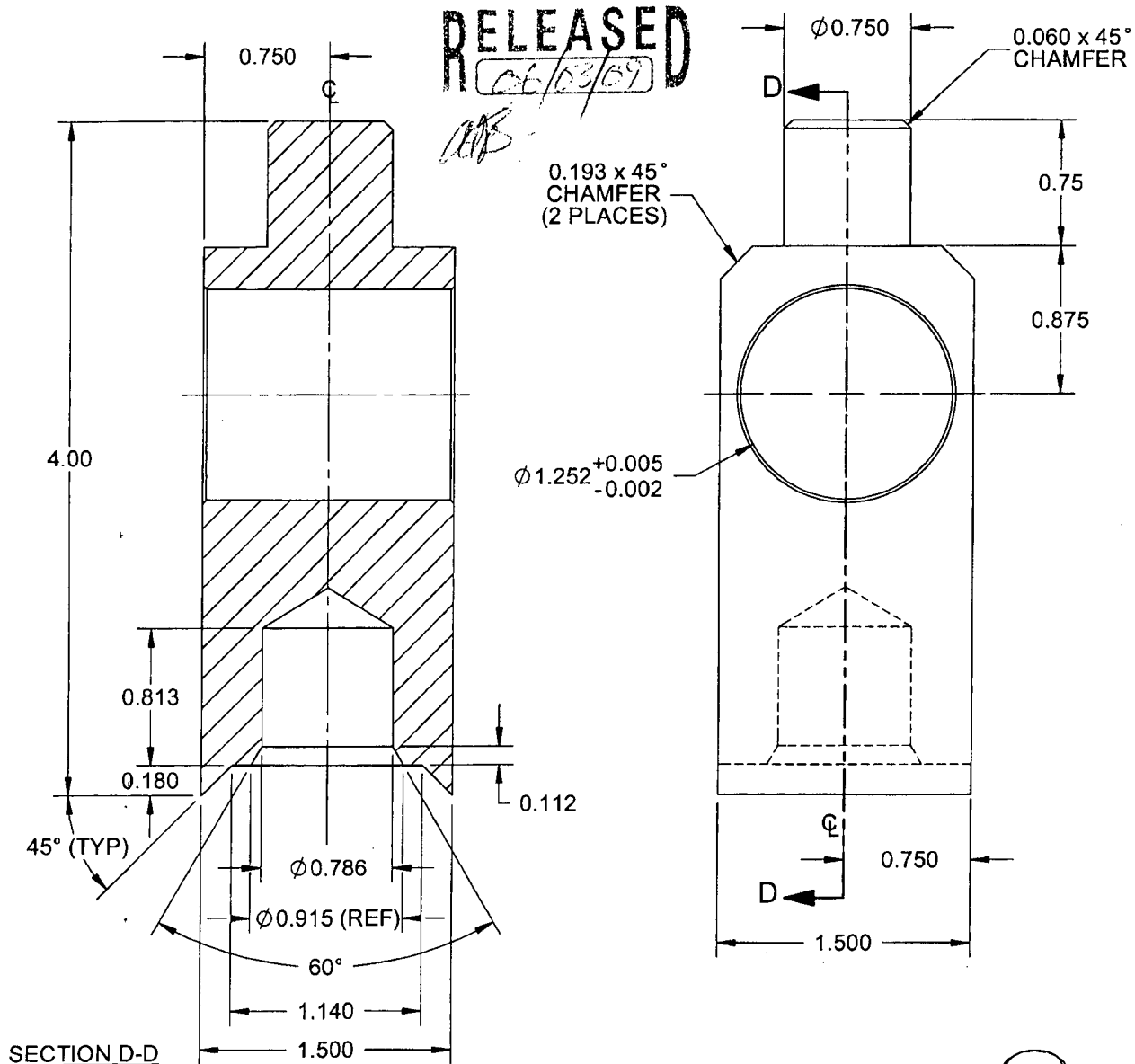
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
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- 3) ALL DIMENSIONS ARE IN INCHES
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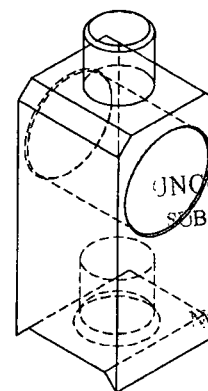
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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